Work Orde September-27-1.			0911	*107	7669*						Page 1
Item ID: Revision ID: Item Name:	646.3911 Shim	646 B10	.3911 7669	Accept	*N900	040	100)* 5	Setup Sta	1.7	S1* S2*
Start Date: Required Date: Reference:	9/27/13 9/27/13	Start Qty: 8.00 Req'd Qty: 8.00	*8*	. *12*	Cust Item I Customer:	D:					
Approvals:		n: _ML5	•	Tooling: SPC (Y/N):		ite:		I	Run Sta St	I <i>/</i>	R1**
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
646.3900	N/C		·								
110	· · · · ·			0.00		,					4
110 Waterjet FLOW CNC Waterj	iet ·	Memo 1-Cut as pe	er Dwg	0.00				19			13.11.
. :		Dwg Rev: Prog Rev:	NIC								
* : :		2-Deburr if									
120		QC2- Inspect parts off r	machine FAI/FAIB	0.00				۰,۵	m		A
120 QC Ouality Control		Memo		0.00				19	<u> </u>		13.11.

Quality Control

NCR:	Yes	/ No				WORK ORDER NON-C	100	VFORM	MANCE / UPI	DATE					•
								, , , , , , , , , , , , , , , , , , , ,			(QA Closed:	Da	ite:	
Work Orde	er:	·				DISPOSITION				AGAINST D	EP.	ARTMENT/	PROCESS		
Part N	-					Rework Scrap Use-as-is		1	Skid-tube Machining noforming	Crosstube Small Fab Finishing			Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other
NCR N	No		<u> </u>			Work Order Update]		Large Fab	Composite		1100/3101	Supplier	_	
Root					Descri	ption of work order update		Initial	Act	tion	T	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	\perp	Date	Verification	'n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
					<u> </u>	F	AUL	T CATE	GORY				<u> </u>		
Landi	ng G	iear				General									
		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspection Ripples in Torque W	Crimped at n Strip in ı Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/ nance iled	Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Turning S	equence			Finish		Out of 9	Sequence		-		<u> </u>		

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

**											
Work Ord				*107	669*						Page 2
Item ID: Revision ID: Item Name: Start Date: Required Date:	646.3911 Shim 9/27/13 : 9/27/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*	Accept	*N900 Cust Item I Customer:		100) *	Setup Sta	I VI	S1* S2*
Approvals:		an:		Tooling: SPC (Y/N):		nte:		I	Run Sta	" \	R1* R2*
Sequence ID/ Work Center I 130 *130* QC Quality Control	D	Operation Description QC8- Inspect parts - sec	ond check	Set Up/ Run HAAFs 0.00 27 9-89	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp.
140 *140* Outsource3 Outsource process	- Cad plate	Outsource process-Cadp Memo Issue P/O:_	Solate per QSI017 4.1.9.1	0.00					Z_13	11/100	2 (2)

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150 Packaging

Memo

0.00

Packaging

(2) 2/14 (2)

											DQA:	Date	:
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	ANCE / UPD	ATE			
											QA Closed:	Date	•
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	No.					Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				:	Descri	ption of work order update		Initial	Actio	on	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descrip	otion	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													·
							FAUI	LT CATE	GORY				
Landi		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio	Crimped at n Strip in		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misread	on Incomplete ions Incomplete/Ur enance eled	nclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
I		Ripples in	ı Bend		l l	Drill Holes	- 1	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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WORK CRUCK ID 10/002	W	ork	Order	ID	107669
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Quality Control

107669

Page 3

September-27-1	3 1:09:37 P	M		1117	1619				
Item ID: Revision ID: Item Name:	646.3911 Shim			Accept	*N900040	100*	k Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date Reference:	9/27/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item ID: Customer:				IV.7/
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):	Date:		Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center I 160 *160* QC Quality Control		Operation Description QC5- Inspect part comp Memo		Set Up/ Run Hougs S 0.00 27 9-89	Tool ID Tool #	Code (Accept Re Qty Qty		Reject Insp. Number Stamp
170 *170* Packaging Packaging		Memo	tock Location: <u>SHC</u> 3	0.00 0.00 -120 BY STAMPING THE	P# AND		/2_	13,	DAS 32 989
*180 *180*		QC21- Final Inspection	- Work Order Release	0.00		_		13	3/12/94

M18-12-5

											DQA	\:D	ate:	د
NCR:	Yes	/ No				WORK ORDER NON-	100	NFORM	MANCE / UP	DATE	QA Closed	I· D	ate:	
						DISPOSITION				AGAINST DE			acc.	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTIVIEN	1/PROCESS		
						Rework			Skid-tube	Crosstube		Water Je	t	Engineering
Part I	No.					Scrap		r	Machining	Small Fab	Pr	od. Eng. Coo	را:	Quality
						Use-as-is			noforming	Finishing	Rec/St	ore/Packagin	_	Other
NCR I	No.	· · · · · · · · · · · · · · · · · · ·				Work Order Update	J		Large Fab	Composite]	Supplie	r	
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &			
Cause		Date	Step	Qty	•	or Non-conformance	Cr	nief Eng	Desc	ription	Date	Verificati	on	QC Inspector
Doc/Data													í	
Equip/Tooling	Ш												ļ	
Operator													l	
Material	Ш													
Setup	Ш													
Other	Н		}											
Process														
Supplier	Н													
Training	<u> </u> -													1
Unapproved				<u> </u>			<u> </u>	LT CATE	CORV		<u> </u>			,
Landi	na (<u> </u>			General	AUI	LICATE	JONT					<u></u>
Land	, E	Bending				Bend	Г	Grain		Г	Ovalized			Pressure/Forced
		Centre No	ot Concei	ntric to		BOM/Route	\vdash	Hardwa	re		_	er tolerance	\vdash	Temperature/Cure
		Cracks	or conce		-	Broken/Damaged		┨	on Incomplete	<u> </u>	Part Incori		-	Weld
	\vdash	Crushed/	Crimped		<u> </u>	Burrs		⊣	ions Incomplete/	/Unclear	Part Lost/		—	Wrong Stock Pulled
	\Box	Cuffs				Contamination	\vdash	Mainte			Part Move	_	L	J
		Heat Trea	at			Countersink		Mislabe		<u> </u>	Positioned			
	П	Inspectio		Tube	-	Cut Too Short		Misread		-	Power Los			Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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· Picklist Print

September-27-13 1:09:37 PM

Work Order ID:

107669

Parent Item:

646.3911

Parent Item Name:

Shim

Start Date: 9/27/13

Required Date: 9/27/13

Page 1

Start Qty: 8.00

Required Qty: 8.00

Co	m	m	er	its	
$-\mathbf{v}$	111		•	ı to	•

IPP REV:A 12.10.23 NEW ISSUE DD VERF:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MC1095S.032 C1095 Blue Tempered Spr	ring Steel Sheet .032	Purchased	No			110	sf	8.5000	0.03	- 0.252631	2 Ac	13.	U08
				Location		Loc Qty	Lo	c Code					
				MAT022		8.5						2	C
				123	537	8.5			12	3537		i 5	X

											1	DQA:	Dat	e:	
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFORM	/IANCE / UPI	DATE				_	
											QA Clo	osed:	Dat	e:	
Work Ord	er.					DISPOSITION				AGAINST DI	PARTN	1ENT	/PROCESS		
Part I	No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Red		Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Rọot					Descri	ption of work order update		Initial	Act	tion	Sign	.			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desci	ription	Da	te	Verification	1	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
						F	AUI	LT CATE	GORY						
Landi		Bending Centre No Cracks Crushed/ Cuffs Heat Trea	Crimped.		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		Instruct Mainte Mislabe	on Incomplete ions Incomplete/I nance led	Unclear	Part In Part Lo Part M Positio	Jnder corre ost/M loved oned \	issing Wrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	-	Inspectio	•	rube	-	Cut Too Short	-	Misread	I	L.	Power	LOSS	/Surge		Other

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

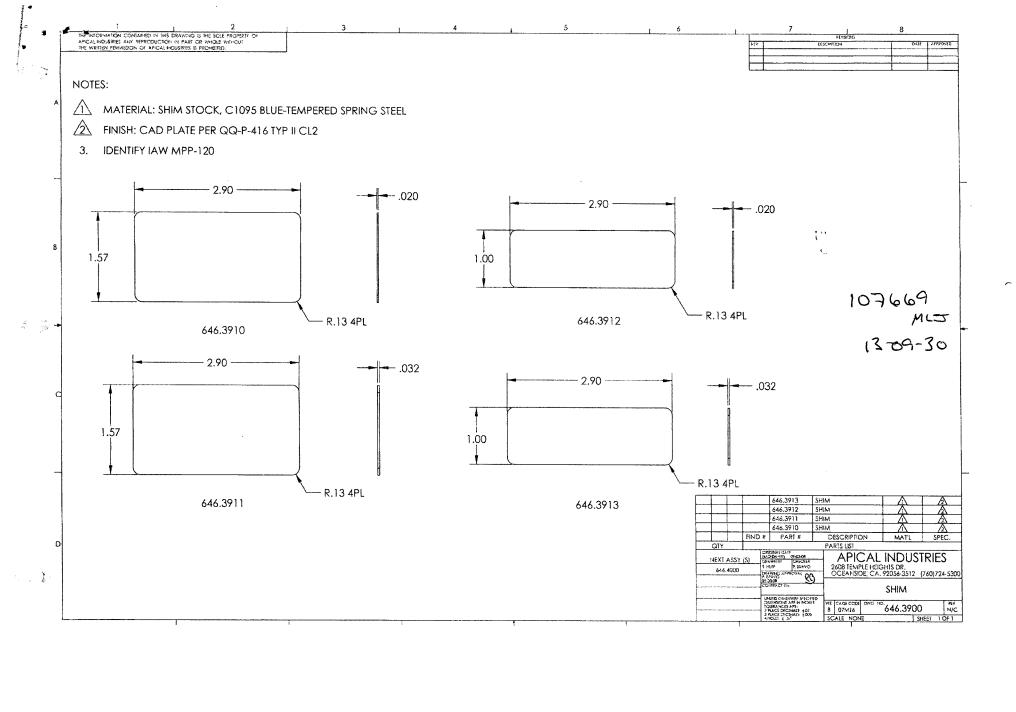
Folio

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DART AEROSPACE LTD	Work Order:	107669
Description: Shim	Part Number:	646.3911
Inspection Dwg: 646.3900 Rev: N/C	· _	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST Drawing _ Actual _ Method of _ Actual _												
Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments							
+/-0.005	1.57"	_		~	JEMOI							
+/-0.005	290"											
+/-0.005	.032"			V								
					·							
		T-01										
		DAS										
	I I	27										
	+/-0.005 +/-0.005	Tolerance Dimension +/-0.005	Tolerance Actual Dimension Accept	Tolerance Dimension Accept Reject +/-0.005	Tolerance							

Measured by: Ac		Audited by:	Prelin	Preliminary Approval:				
Date: 13 11 100			Date: 13 // 04		Date:			·
Rev	Date	Change				Revise	d by I N	Approved
Α	12.11.30	New Issue				KJ	14	AA



CERTIFICATE OF CONFORMANCE

CADORATH PLATING CO. LTD. 2150 LOGAN AVENUE WINNIPEG, MANITOBA R2J-0J1

DATE:

Dec-02-2013

CONSIGNED TO: Dart Aerospace Ltd.

1270 Aberdeen St.

Hawksbury, ON K6A 1K7

W/O #:

130249

INVOICE #:

68742

CONTRACT OR

PURCHASE ORDER #

PO21961

DESCRIPTION:

SHIM

QTY

12

P/N # 646.3911

S/N # 107669

CADMIUM PLATING IAW AMS-QQ-P-416C TYPE 2 YELLOW CLASS 2. BAKE HEAT CHART # 13-1051.

CERTIFICATE: I certify that the items indicated here on have been inspected and tested and conform to all specifications and requirements detailed on the contract or purchase order.



Approved Inspector: